

IN THE CLAIMS:

Please amend the claims as follows:

1. **(Currently Amended)** A through weld method ~~applied to aluminum or aluminum alloy welding base metals~~ using high energy beams, the method comprising the following steps:

a positioning step of positioning a first aluminum or aluminum alloy welding base metal opposite a source of the energy beams, the first welding base metal having a first surface and a second surface opposite the first surface;

a disposing step of disposing a second aluminum or aluminum alloy welding base metal beneath the first welding base metal, the second welding base metal having a first surface and a second surface opposite the first surface, wherein the second surface of the first welding base material abuts a first surface of the second welding base metal; and

a supplying step of supplying wherein an ambience of a shield gas to form ambience over ~~is formed to cover a submerged-scar made on~~ projecting from a welding site defined on the second surface of said the second welding base metal, as well as the shield gas to push a scar projection from the welding site on the second surface of the second welding base metal, wherein a vertical height of a submerged scar is reduced ~~metals at a side of penetrating out of said high energy beam through said welding base metals.~~

2. **(Currently Amended)** A The through weld method ~~applied to aluminum or aluminum alloy welding base metals using high energy beams~~ according to Claim 1, wherein an inert gas is used for ~~said the~~ the shield gas.

3. **(Currently Amended)** A The through weld method applied to ~~aluminum or aluminum alloy welding base metals using high energy beams~~ according to Claim 2, wherein argon gas, nitrogen gas or helium gas is used for ~~said~~ the inert gas.

4. **(Currently Amended)** A The through weld method applied to ~~aluminum or aluminum alloy welding base metals using high energy beams~~ according to Claim 1, further comprising:

a fixing step of fixing the first and second welding base metals onto a mounting stage, wherein ~~said welding base metals are fixed onto a~~ the mounting stage which comprises:

a chamber constructed therein,

an open hole that opens at an upper side of ~~said~~ the mounting stage which opens to ~~said~~ the submerged-scar and leads ~~said~~ the shield gas supplied to ~~said~~ the chamber, and

a shield gas supply that provides ~~said ambience of~~ said shield gas ambience in said to the chamber.

5. **(Currently Amended)** A The through weld method applied to ~~aluminum or aluminum alloy welding base metals using high energy beams~~ according to Claim 1, further comprising:

a fixing step of fixing the first and second welding base metals ~~wherein; said welding base metals are fixed~~ onto a mounting stage [[,]]; and

~~said~~ a using step of using a shield gas supply to provide the ambience shield gas, the shield gas supply including ~~is provided by a shield gas supply that comprises a~~

~~nozzle to supply said shield gas and a manipulator to move and position said~~ the shield gas supply nozzle against said beneath and opposite to the submerged-scar.

6. **(Currently Amended)** A The through weld method ~~applied to aluminum or aluminum alloy welding base metals using high energy beams~~ according to Claim 1, ~~[[4]]~~ wherein said the shield gas supply nozzle is set upward arranged to supply said the shield gas in a direction that is orthogonal relative to the second surface of the second welding base metal vertical to said submerged-scar.

7. **(New)** The through weld method according to Claim 6, wherein the shield gas supply nozzle moves beneath the welding metals in accordance to advancing the welding beam of the through weld thereon.

8. **(New)** The through weld method according to Claim 1, wherein the shield gas supply nozzle is arranged to supply the shield gas in a direction that is oblique relative to the second surface of the second welding base metal.